

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-018860**Date Inspected:** 22-Dec-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 1000**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1830**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site

CWI Name:	Fred Von Hoff and John Pagliero			CWI Present:	Yes	No	
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No	N/A
				Delayed / Cancelled:	Yes	No	N/A
Bridge No:	34-0006			Component:	Orthotropic Box Girder		

Summary of Items Observed:

Caltrans Office of Structural Material (OSM) Quality Assurance Inspector (QAI) Joselito Lizardo was present at the Self Anchored Suspension (SAS) job site as requested to perform observations on the welding of components for the San Francisco Oakland Bay Bridge (SFOBB) Project.

At OBG 7E/8E side plate 'C' inside, QA randomly observed ABF/JV qualified welder Fred Kaddu ID # 2188 perform CJP groove welding repair. The welder was observed welding in the 3G (vertical) position utilizing Shielded metal Arc Welding (SMAW) with 1/8" diameter E7018H4R electrode implementing welding procedure ABF-WPS-D15-1001-Repairs. The boat shape repair excavations having various dimensions were preheated to more than 140 degree Fahrenheit using propane gas torch prior welding. During the shift, ABF QC Fred Von Hoff was noted monitoring the welder. Prior welding, ABF QC John Pagliero was also observed performing Magnetic Particle Testing (MT). There were no defects noted during the test. Repair welding at this location was still continuing at the end of the shift and should continue tomorrow. The following first time repairs were noted excavated and completely welded at the end of the shift;

Location	Y-dimension	Length	Depth	Remarks
1. C1	3120mm	80mm	5mm	Excavated
2. C1	500mm	90mm	9mm	Excavated
3. C1	3090mm	110mm	12mm	Excavated
4. C1	4680mm	80mm	5mm	Completed
5. C1	4920mm	80mm	5mm	Completed
6. C2	2030mm	140mm	8mm	Completed

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At OBG 5E/6E LS1 longitudinal stiffener inside, QA randomly observed ABF/JV qualified welder Xiao Jian Wan ID #9677 perform CJP groove welding repair. The welder was observed welding in the 3G (vertical) position utilizing Shielded Metal Arc Welding (SMAW) with 1/8" diameter E9018H4R electrode implementing welding procedure ABF-WPS-D15-1002-Repairs. The repair excavations were preheated to more than 200 degree Fahrenheit using propane gas torch prior welding. During the shift, ABF QC John Pagliero was noted monitoring the welder. Prior welding, ABF QC John Pagliero was also observed performing Magnetic Particle Testing (MT). Repair welding at this location was completed at the end of the shift.

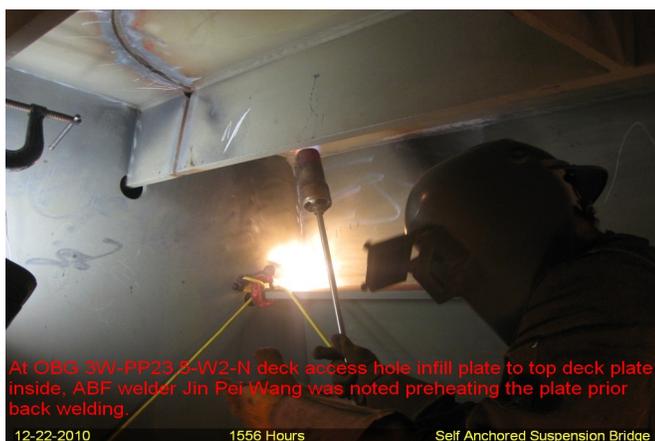
Location	Y-dimension	Length	Depth	Remarks
1. 5E/6E LS1	70mm	100mm	16mm	Completed
2. 5E/6E LS1	140mm	95mm	16mm	Completed

At OBG 6E-PP46.5-E2-S and 5E-PP29.5-E2-S deck access hole infill plate to top deck plate inside, ABF welders Wai Kitlai and Hua Qiang Wang respectively 4G welding undercut repair on the welded butt joint. Both welders were observed welding utilizing Shielded Metal Arc Welding (SMAW) with 1/8" diameter E7018H4R electrode implementing welding procedure ABF-WPS-D15-1001-Repairs. During the shift, ABF QC John Pagliero was noted monitoring the welders and their welding parameters. At the end of the shift, undercut repairs on both locations were completed.

This QA performed 10% MT verification at the following edge plate and longitudinal stiffeners welded butt joints.

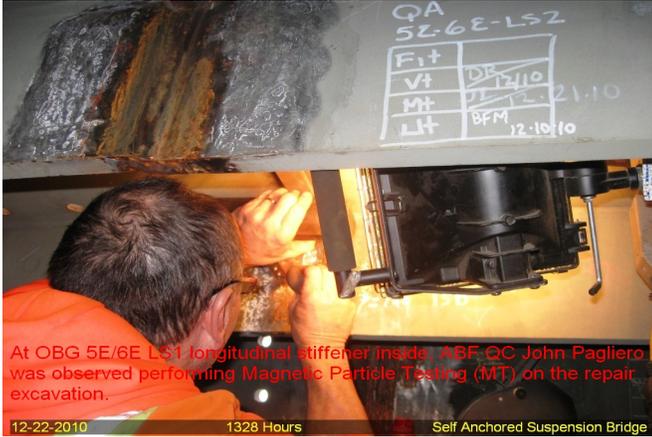
Please see TL-6028 report for more information.

1. OBG 3E-PP22-E3-#1 to #4 lifting lug access hole restoration inside – no defects noted.
2. OBG 3E-PP20-E3-#1 to #4 lifting lug access hole restoration inside – no defects noted.
3. OBG 8E/9E top deck plate A1 to A5 outside – no defects noted.



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Summary of Conversations:

No significant conversation occurred today.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact SMR Nina Choy, 510-385-5910, who represents the Office of Structural Materials for your project.

Inspected By: Lizardo, Joselito

Quality Assurance Inspector

Reviewed By: Levell, Bill

QA Reviewer